

Work Order ID 63251

Tuesday, October 26, 2010 2:33:09 PM



Page 1

Item ID: D212-725-1-099

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 10/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-10-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

6061 .125

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

1310-10-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1310-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 10/10/27

(74)

QC

Memo

0.00

Quality Control

130

0.00

Small Fab

Memo

0.00

Small Fab

1- Grind a 45 degree chamfer as per dwg.

⇒ m. k 10/10/27

(4X)

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 10/10/28

(74)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D212-725-1-099

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Revision ID:

Stop

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Start Date: 10/26/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

FLAT PATTERN ONLY

4 10-10-28

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Carpenter (4)

170

Identify as per dwg & Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

Carpenter (4)

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29

10-10-28

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 2:33:14 PM

Page 1

Work Order ID: 63251

Parent Item: D212-725-1-099

Parent Item Name: Radius Block


Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.26 as per dwg rev.G DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	91.4600	0.0147	0.061895			
													
6061-T6 .125 Sheet													

Location

Loc Qty

Loc Code

MAT21

91.46

113608

91.46

113608

④

10-10-27

W/O:		WORK ORDER CHANGES					
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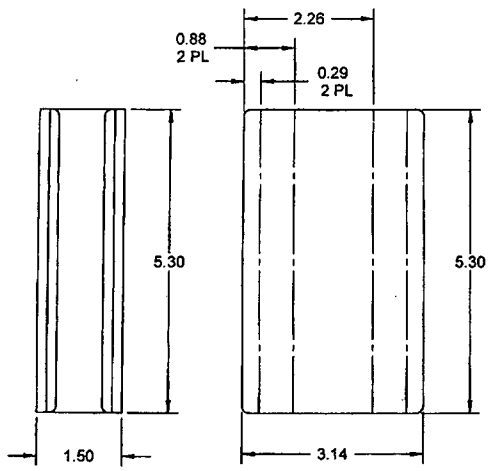
D212-725-1-099

☒ **First Article** ☐ **Prototype**

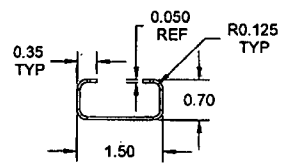
Measured by:	EB	Audited by:	8	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/27	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

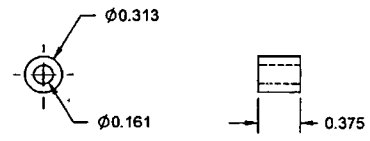
8 7 6 5 4 3 2 1



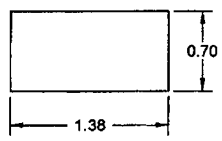
D212-725-1-081F FLAT PATTERN



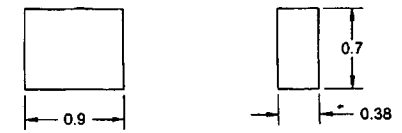
D212-725-1-081 SUPPORT
(MAKE FROM D212-725-1-081F FLAT PATTERN)



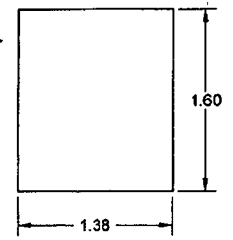
D212-725-1-101 SPACER



D212-725-1-095 RADIUS BLOCK



D212-725-1-097 PACKER



D212-725-1-099 RADIUS BLOCK

- D212-725-1-095/-097/-099 NOTES:**
 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
 REF DART SPEC. M6061T6B
 OR 6061-T6/T62 ALUMINUM SHEET
 PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
 REF DART SPEC. M6061T6S
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

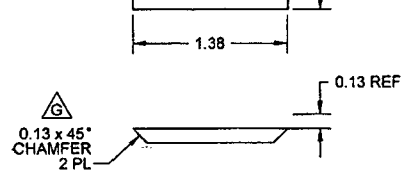


- D212-725-1-101 NOTES:**
 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC. M6061T6R
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



- D212-725-1-081 NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED, 2B FINISH 0.050 (18 GAUGE) THICK
 PER AMS-5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
 REF DART SPEC. M304S18GA
 2) FINISH: NONE

- GENERAL NOTES:**
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



RELEASED

10.02.71

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. G
MFG. APPR.	140	D212-725-1	SHEET 31 OF 84
APPROVED	140	TITLE	SCALE
DE APPR.	140	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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 WORK ORDER
 NO. 632-51
 2810-1026

W/O:		WORK ORDER CHANGES					
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